

ABSTRACT

A roof panel (31) is pre-set on the left and right side members (4) fixed to an underbody of a car. A roof panel spot
5 welding station (7) includes a pair of frames (34) and two
joisted-locating jigs (35, 36) bridging the frames. Each of
the joisted-locating jigs is furnished with a clamp mechanism
for holding the roof panel. The roof panel is located to the
side members by the locating jigs, and spot-welded to the side
10 members.